

Date: Thursday, 10/04/2008 4:00:50 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SKIDTUBE ASSEMBLY RH
Job Number : 38546	
Estimate Number : 10265	
P.O. Number :	Part Number : D350636012
This Issue : 10/04/2008 S.O. No. :	Drawing Number : D2750 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : E
Previous Run : 38545	Material :
Written By :	Due Date : 05/05/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08-4-08</u>	
Comment : Est Rev:I 02-09-25 Rearranged procedure steps KJ Est Rev:J 06-03-29 As per Rev D EC Est Rev:K 06-07-13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Photocopy blue file and type labels per PPP D350-636-012 CHG 003

End of dc 8-4-22 JLD

2.0	D26003BENT
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D2600-3-Bent

Extrusion (Bent)

B38463

① N 8-4-24

3.0	D2744
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Cap

Batch:

B33996

① N 8-4-24

4.0	SKIDTUBES 1
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SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut

8-4-22 N

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329

5-Open up holes for Detail B to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube*****

Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod M106330 RE 08/04/25

10-Grind welds flush as per Dwg D2750

~~SL 8-4-24~~ SL 8-4-28

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8-4-28 (H)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8-4-28 (H)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8-4-28 (H)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8-4-28

9.0

D2739



Comment: Qty.: 1.00000 Each(s)/Unit Total: 1.00000 Each(s)

* Web Batch: B38587

8-4-28

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10.0

D34901



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Crossbolt spacer

Batch: *23824*

BE 08/04/30

11.0

D34903



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Crossbolt spacer

Batch: *23825*

BE 08/04/30

12.0

D2743



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

Crossbolt spacer

Batch: *232656*

BE 08/04/30

13.0

SKIDTUBES 1



SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on
sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

1107804

exp. date:

3-10-1

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

8-4-28

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Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

A/R Aluminum Rod batch: *M107263 BE 08-04-30*

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

M 8-4-30

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/04/30 @

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/30 @

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M. 08/05

*1338546
D350636012
01/05/2008*

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M 107350

*S.171 09.07
#1 317.7 F
#2 --- F
#3 30min F
#4 --- F*

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

BR 08-05-02

19.0

ALS41032225



Comment: Qty.: 42.00000 Each(s)/Unit Total: 42.00000 Each(s)

Insert

Batch

M 100789

BR

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

BR 08-05-02

BR 08-05-05

Form: rprocess

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Job Number: 38546

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D2745	
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Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

Bushing

Batch: B 37303

BR

22.0	D353513	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

WEARSHOE

Batch: B 37584

BR

23.0	D353525	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

WEARSHOE

Batch: B 38162

BR

24.0	D353535	
------	---------	--



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

WEARSHOE

Batch: B 38760

BR

25.0	D353613	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

GASKET

Batch: B 38554

BR

26.0	D353625	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

GASKET

Batch: B 38565

BR

27.0	D353635	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

GASKET

Batch: B 37352

BR

W/O:		WORK ORDER CHANGES					
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Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0

D35371



Comment: Qty.: 5.00000 Each(s)/Unit Total : 5.00000 Each(s)

WEARPAD

Batch: B 36426

BR.

29.0

D36311



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

WASHER

Batch: B 38139

BR

30.0

D3488042



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Blade Fitting RH

Batch: B 35587

BR.

31.0

D3492041



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

PLUG ASSEMBLY

Batch: B 38182

BR.

32.0

D3492043



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

PLUG ASSEMBLY

Batch: B 38467

BR.

33.0

AN3C5A



Comment: Qty.: 38.00000 Each(s)/Unit Total : 38.00000 Each(s)

Bolt

Batch: M 107 737

BR.

34.0

AN3C6A



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Bolt

Batch: 105300

BR.

BR 08-05-05 ①

W/O:		WORK ORDER CHANGES					
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Job Number: 38546

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	AN3C7A	
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Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

BOLT

Batch: M107376

BR.

36.0	AN6C44A	
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Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

BOLT

Batch: M107685

BR.

37.0	AN8C35A	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

BOLT

Batch: M106896

BR.

38.0	AN960C10L	
------	-----------	--



Comment: Qty.: 46.00000 Each(s)/Unit Total : 46.00000 Each(s)

washer

Batch: M107737

BR.

39.0	AN960C816L	
------	------------	--



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: M106513

BR.

40.0	MS210436	
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Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

NUT

Batch: M107736

BR.

41.0	MS21083C8	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

NUT

Batch: M107756

BR.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 38546

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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42.0	NAS1515H3L	
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Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

WASHER

Batch: M106516

BR

43.0	NAS1515H8L	
------	------------	--



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: M107558

BR

44.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: M106096

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M107804

EXP DATE: 08-10

4-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

BR 08-05-05

45.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8 08/05/05 (V)

46.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0	D2741	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Blade

Batch: 36343

8/5/5

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 38546

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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48.0	AN960C816L	
------	------------	--



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

Washer

Batch: 107520

SP

49.0	MS21083C8	
------	-----------	--



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

Nut

Batch: 107756

SP

50.0	AN8C21A	
------	---------	--



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

Bolt

Batch: 107596

SP

51.0	NAS1515H8L	
------	------------	--



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: 107881

SP

52.0	D34931	
------	--------	--



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: 38102

SP

53.0	D35321	
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Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

spacer

Batch: 38161

SP

ix

SP

54.0	QC4	
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INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SP

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev
f

KS 08/05/06
(14)

56.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-06

38546

Dart Aerospace Ltd

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DART**RELEASED**
07.08.02

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D2750	REV. E SHEET 1 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38546

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DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

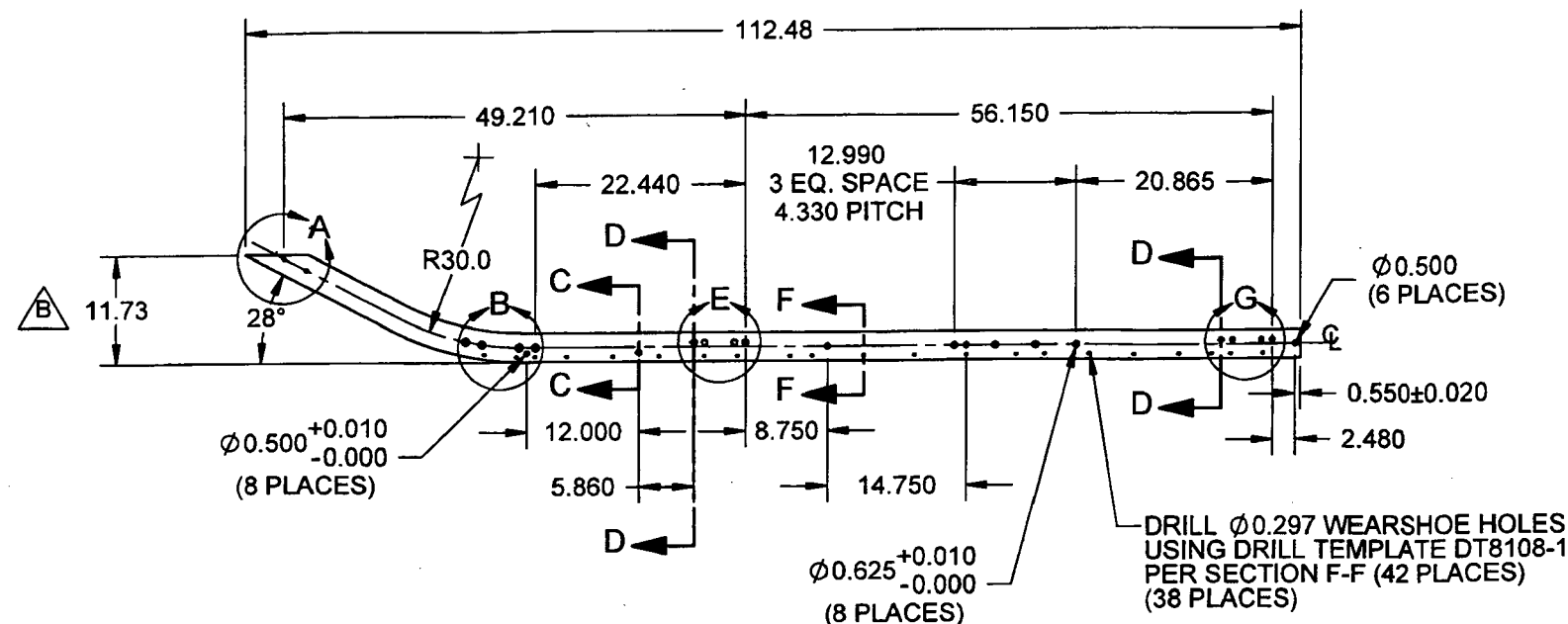
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1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OF POWDER COATING WITH MEK DEGREASER.

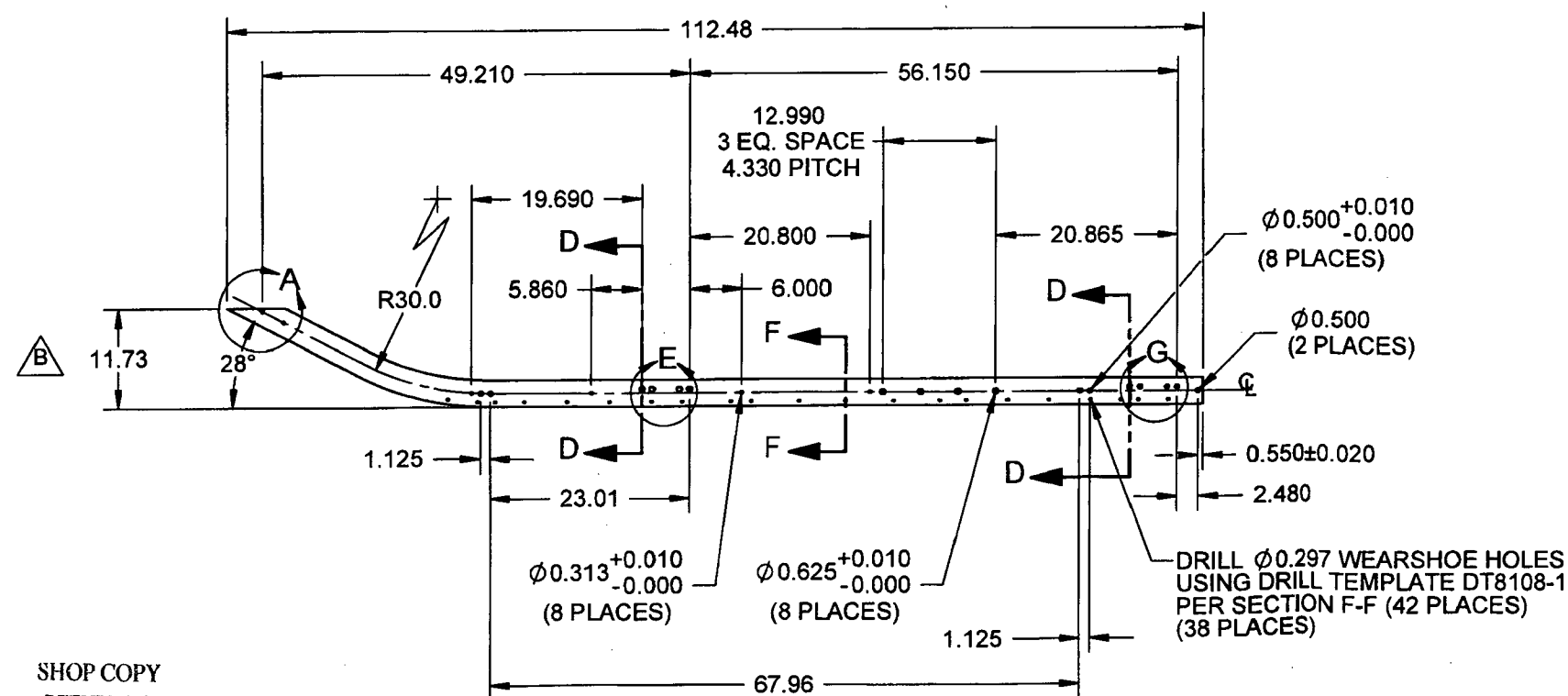
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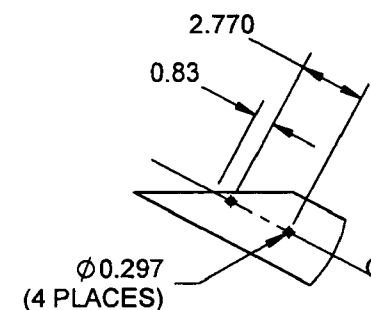
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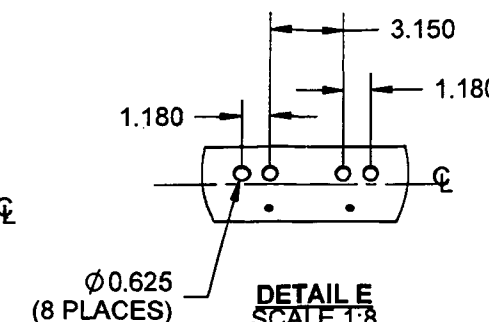
D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



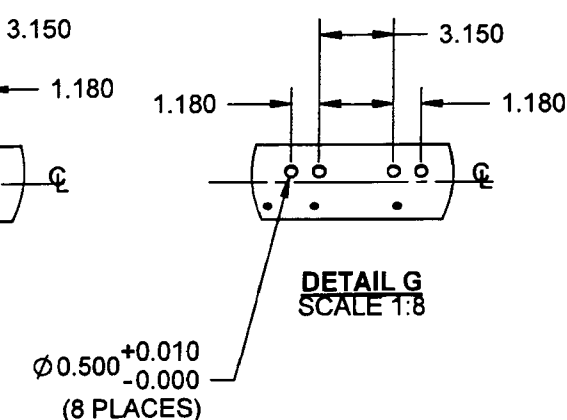
D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



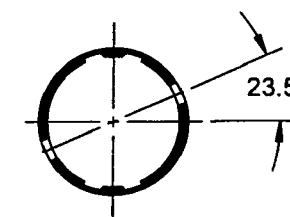
DETAIL A
 SCALE 1:8



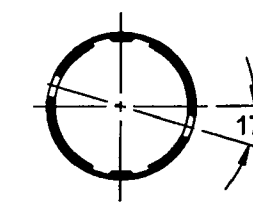
DETAIL E
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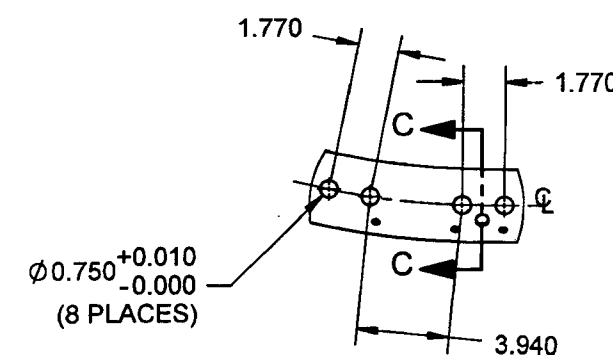
DETAIL G
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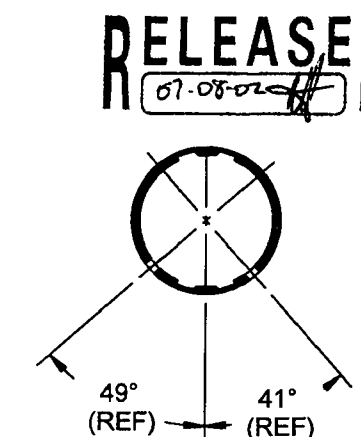
SECTION C-C
 SCALE 1:4



SECTION D-D
 SCALE 1:4



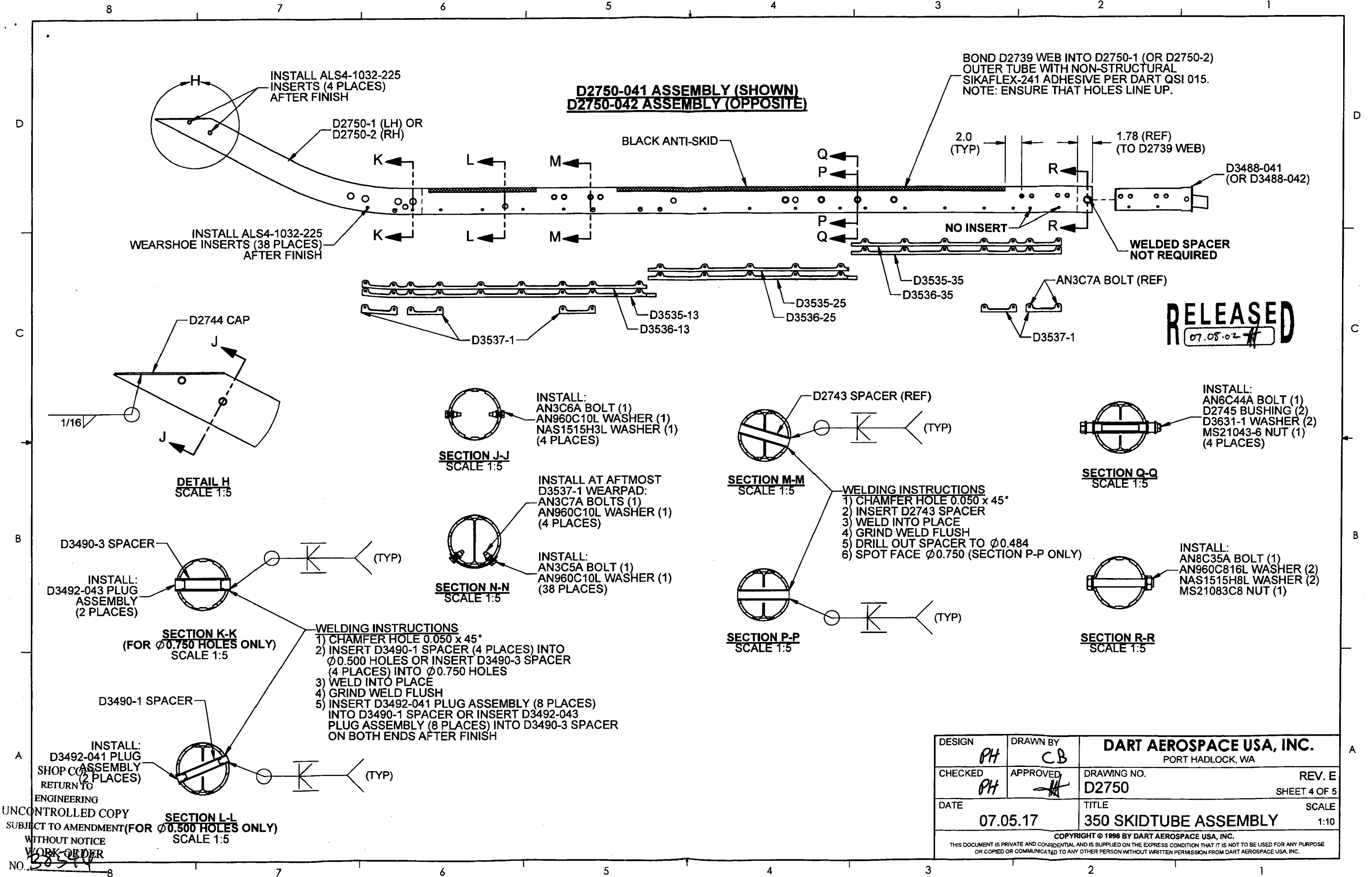
DETAIL B
 SCALE 1:8
 (ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)



SECTION F-F
 SCALE 1:4

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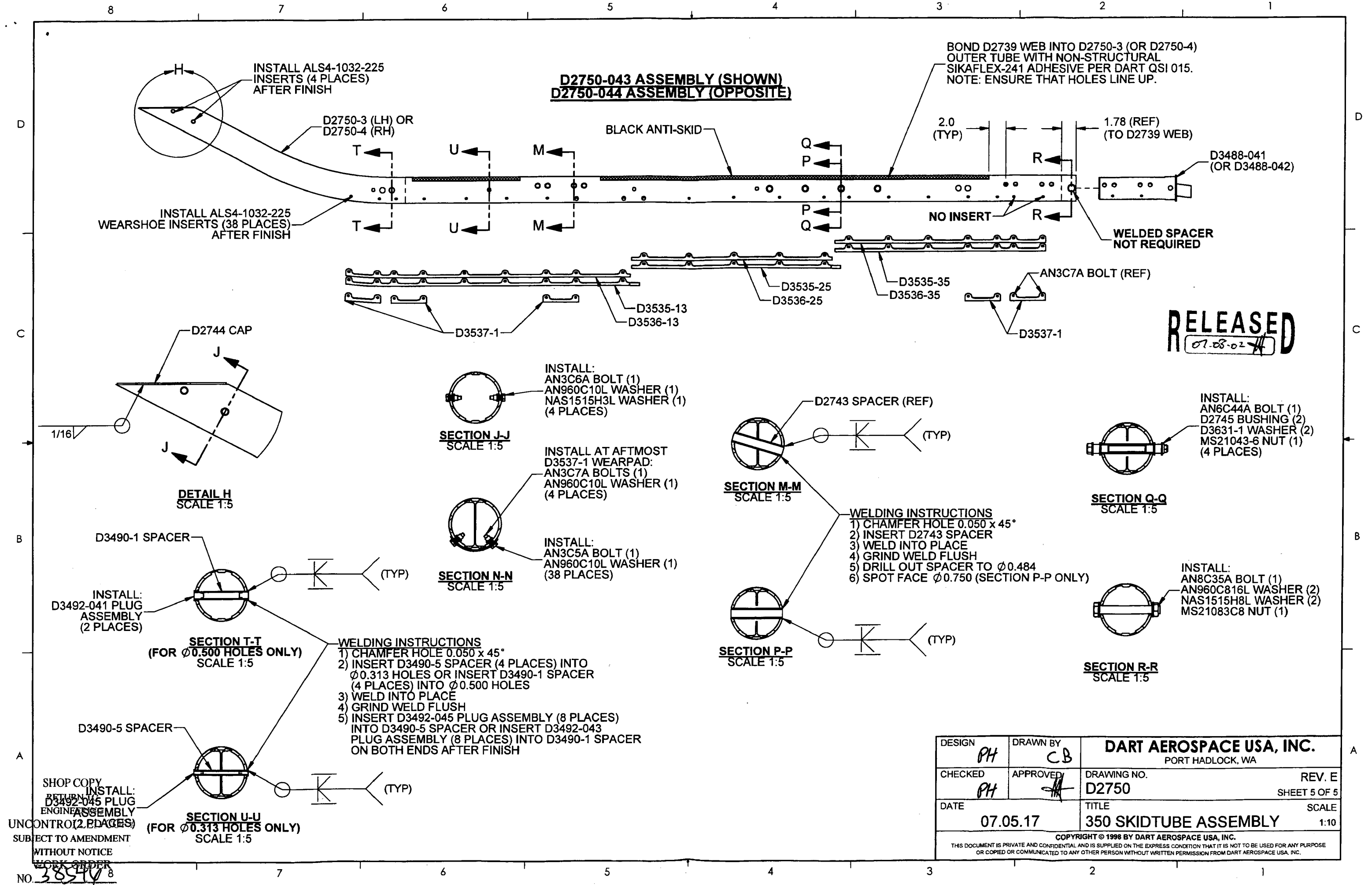
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DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20
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DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10
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